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RB877212-08-16
Job Sheet 192387



Part No: RB877212-08-16

Job Qty: 1 pcs

Part Name: Removal and Installation Tool Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/22/19

Job Tracking No:

Due Date: 5/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *Order 13636*

Note: DWG RB877212-08 REV D IPP Rev. A 19.03.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	5/3/19	0.00	0.20		Small Fab - 1		DAS
							Small Fab - 2		71
							Small Fab - 3		9-89
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	5/3/19	0.00	0.00		QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	1 pcs	5/3/19	0.00	0.00		Packaging 3 - 1 - B4B		DAS
							Packaging 3 - 2 - B4B		40
							Packaging 3 - 3 - B4B		9-89
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		DAS
							Packaging 3 - 7 - B4B		28
							Packaging 3 - 8 - B4B		9-89
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - SA	1 pcs	5/3/19	0.00	0.00		QC 21 - SA - 21		DAS
							QC 21 - SA - 70		21
							QC 21 - SA - 53		9-89

Part Op 100 - Assemble as per DWG.

Descriptions: 120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

GA141E

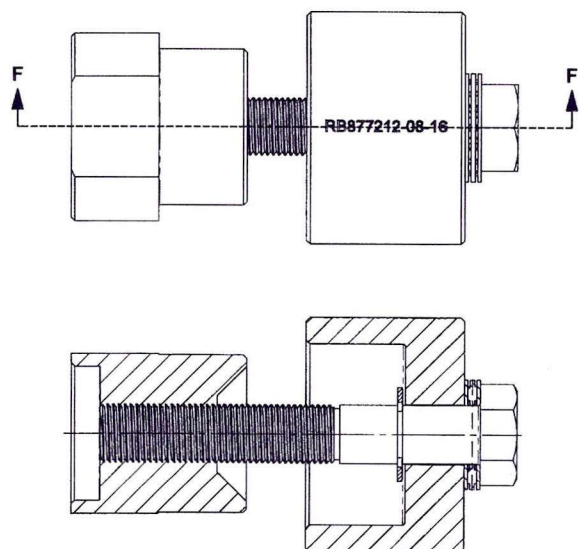
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
98407A138	Zinc Plated Spring Steel Side-Mount External Retaining Ring for Groove 0.396" OD. X 0.046" WD.	1 (1 ea)	100-Small Fab - 1	268176 40
NTA-815	Thrust Bearing	1 Ea (1 ea)	100-Small Fab - 1	5033969 34
RB877212-08-17 R&I Adapter, Ø1-5/8 x 1-1/2		1 pcs (1 ea)	100-Small Fab - 1	5176357 141E
RB877212-08-21 Cap, Ø2 x 1-3/8		1 pcs (1 ea)	100-Small Fab - 1	5170101 96
RB877212-08-27 Bolt, 1/2-20 UNF x 3-1/4		1 pcs (1 ea)	100-Small Fab - 1	5176734 141E
TRA-815	Bearing Washer	2 Ea (2 ea)	100-Small Fab - 1	5036194 36

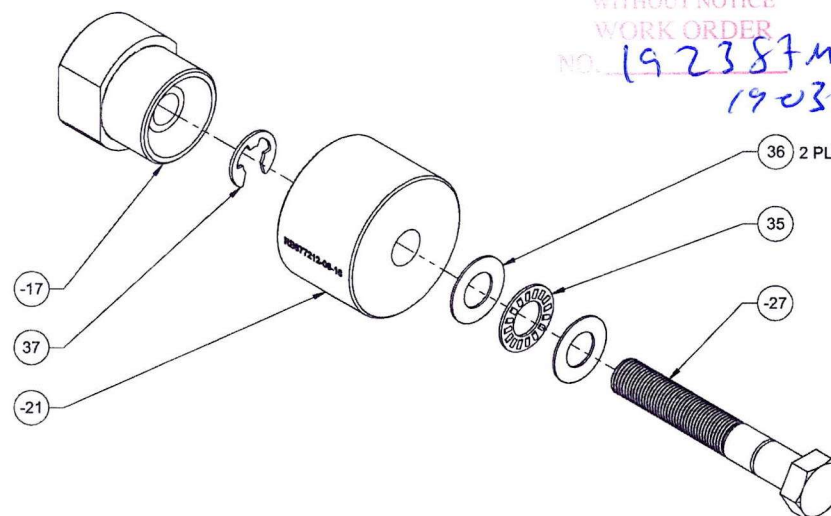
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	98407A138	1	0	0
	NTA-815	1	19	0
	RB877212-08-17	1	0	0
	RB877212-08-21	1	0	0
	RB877212-08-27	1	0	0
	TRA-815	2	36	0
Part Specifications				
Specifications could not be found.				

Plex 3/22/19 9:22 AM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-17	1	RB877212-08-17	R & I ADAPTER
-21	1	RB877212-08-21	CAP
-27	1	RB877212-08-27	BOLT
35	1	NTA-815	NEEDLE ROLLER THRUST BEARING 1/2" ID. X 15/16" OD. X 5/64" WD.
36	2	TRA-815	THRUST WASHER 5/16" ID. X 3/4" OD. X 0.03" WD.
37	1	McMaster#98407A138 OR EQUIV.	ZINC PLATED SPRING STEEL SIDE-MOUNT EXTERNAL RETAINING RING FOR GROOVE 0.396" OD. X 0.046" WD.



SECTION F-F



RB877212-08-16 BEARING REMOVAL & INSTALLATION TOOL ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192387mc
1903-22

DESIGN	MBB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RB877212-08 TITLE TAIL ROTOR BEARING CUTTER SCALE NTS	REV. D SHEET 7 OF 11
DRAWN	MBB		
CHECKED	MBB		
MFG. APPR.	DP		
APPROVED			
DATE 3/21/2019			

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					